

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004779**Date Inspected:** 09-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island, Shanghai

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG components				

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

Section OBG bottom.

1. The QA Inspector performed a random Visual (VT) and Ultrasonic Testing (UT) verifications on the Complete Joint Penetration (CJP) butt splice welds identify as weld number: bp041-001-019 and 021 on inspection part bp41, bp0176-001-019 and 021 on inspection part bp176, bp068-001-023 and 025 on inspection part bp68, bp0149-001-019 and 021 on inspection part bp149, bp095-001-019 and 021 on inspection part bp95, bp0122-001-019 and 021 on inspection part bp122, bp042-001-061 on inspection part bp42, bp123-001-061 on inspection part bp123, bp0150-001-061 on inspection part bp150 and bp0177-001-061 on inspection part bp177. All these welds are part of the OBG bottom assembly section. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001380 and 001379 for additional information. (Please see note below). The QA Inspector performed the UT verification after ZPMC QC Inspectors reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any rejectable welding discontinuities on any of the verified welds mentioned above. The QA Inspector notified ZPMC QC Inspection personnel of the QA Inspector verification results. Please see the QA Inspector Ultrasonic Test report (TL 6027) generated on this date for additional information.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

NOTE: At the time of verifications at this location the QA Inspector was notified by ZPMC QC Inspection personnel completed welds other than those verified by the QA Inspector had been tested and accepted by ZPMC QC Inspection personnel and were ready for verification. The QA Inspector did not observe any written sign on the steel next to the welds showing the QC Inspector's acceptance of the welds. The QA Inspector relayed to the ZPMC QC Inspection personnel the acceptance of the tested welds needed to be written on the steel by the technician prior to the QA Inspector's verification. ZPMC QC Inspection personnel got in touch with the technician and relayed to QA Inspector technician will sign the tested welds tomorrow during the day shift.

Summary of Conversations:

As noted in the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
